

Date  
UserWednesday, 5/16/2007 1:29:44 PM  
Kim Johnson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 206L /407 STEP ASSY, LH

Job Number : 32391A

Estimate Number : 11702

P.O. Number : N/A

This Issue : 5/16/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Previous Run : 32249A

Type : LARGE FAB ASSY

Part Number : D2724041

Drawing Number : D2724 REV C

Project Number : N/A

Drawing Revision : C

Material : N/A

Due Date : 6/15/2007

Qty: 4 Um: Each

Written By : 07.05.16Checked & Approved By : 07.05.16

Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description

1 D2622-120C Extrusion

Batch: 331984

Check Material for any Dents or Defects

F.F.

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding07.05.31

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description

2 D2734 End Cap

Batch: 32934007.05.31

4.0

D34581

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

2 D3458-1 Plate

Batch: 331013 = 807.05.31

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Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

31074=8  
321

SE.07.05.04

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD

Batch:

MIC2756  
MIC3317

Grind end cap welds flush

Q.M. 07.06.04 (4)

SE.07.06.01 4  
SE.07.06.01 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

(LH) 07/06/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-05 (4) (LH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M. 07.06.07

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-06-07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SE.07.06.11 4

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation: Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: *M102756*

Grind per dwg D2724

12.0

QC5/9

WELD INSPECTION



*QC5 07-06-13 (4)*



Comment: WELD INSPECTION

*LH*

*M 07/06/13*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

14.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI 005)

-CLEAR DELFLEET

*Atelier  
Debrossage*

*P.U. 4034 C207/06/25 (1)*

15.0

QC14

INSPECT SPRAY PAINT



*June 22 (1)*



Comment: INSPECT SPRAY PAINT

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*M104733*



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

*FR 07/06/25 (1)*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*June 26 (1)*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ppp 32391*

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

190

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

207106126

Job Completion

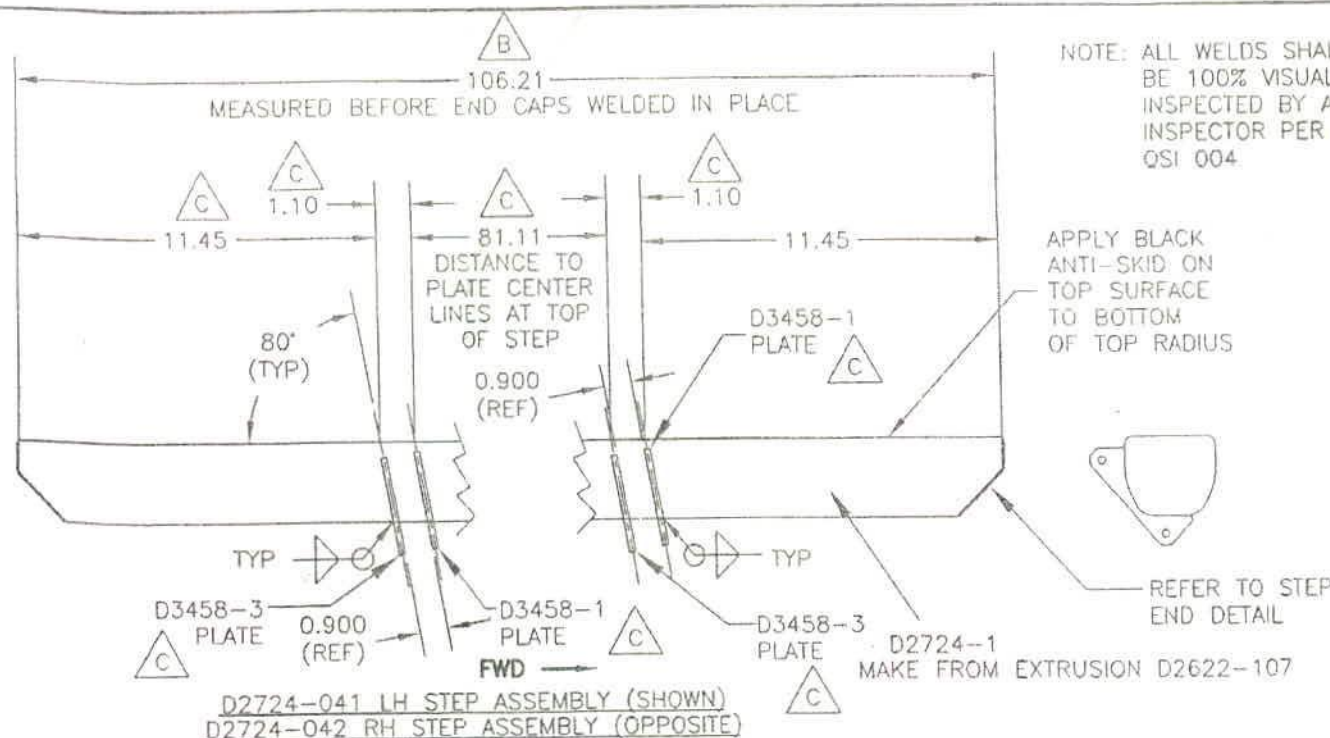


U 07.06.26

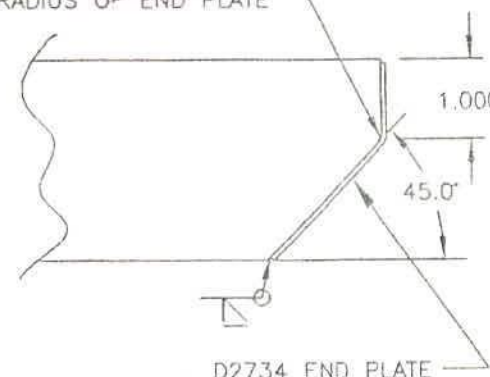
**DART**

RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004.



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

# D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

## D2724-041/-042 STEP ASSEMBLY

- MAKE FROM EXTRUSION D2622
- WELD PER DART QSI 004
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- ALL DIMENSIONS ARE IN INCHES
- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				NIS
				SCALE
				SHEET 1 OF 1
				REV. C